

Work Order ID 74878

October 13, 2011 10:41:45 AM

74878

Page 1

Item ID: D3278-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Support

Stop

NS2

Start Date: 10/13/11 Start Qty: 40.00

40

Cust Item ID:

Required Date: 10/27/11 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: M.L.JDate: 11/10/11 Tooling: _____ Date: _____

Run

Start

NR1

QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
100 Bandsaw	BAND SAW								
Jeaspa Bandsaw	Memo	0.00	<i>SL/10/21</i>			<i>40</i>	<i>0</i>		
	Cut blank: 2.00" x 1.00" x 2.550" long								
110		0.00							
110 HAAS 1	HAAS CNC VERTICAL MACHINING #1					<i>40</i>	<i>0</i>		
HAAS CNC vertical machine #1	Memo	0.00							
	1- Machine as per Folio FA405 and Dwg D32782- Deburr and TumbleIdentify as D3278-1		<i>SL/B.A 11/10/27</i>						
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120 QC	Memo	0.00							
Quality Control			<i>SL/B.A 11/10/27</i>			<i>40</i>	<i>0</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: NC Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74878

October 13, 2011 10:41:45 AM

74878

Page 2

Item ID: D3278-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Support

Start Date: 10/13/11 **Start Qty:** 40.00

40

Cust Item ID:

Required Date: 10/27/11 **Req'd Qty:** 40.00

40

Customer:

Reference:

Approvals: **Process Plan:** _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

130

QC8- Inspect parts - second check

0.00

RE 11-10-28

40

8

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

9:30

0.00

325° F

10:00

MIS43A

40x 11/11/01

10 BK 11-10-31.

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 1

October 13, 2011 10:41:50 AM

Work Order ID: 74878

74878

Parent Item: D3278-1

D3278-1

Parent Item Name: Support

Start Date: 10/13/11

Required Date: 10/27/11

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: A04.04.19 New issue KJ/JLM
IPP B 07.09.06 rev.c dwg EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	43.9660	0.2337	9.84			

M6061T6R1 000X02 000

6061-T6 Bar 1.00 x 2.00

**

Location	Loc Qty	Loc Code
MAT004	43.966	
112567	16.6	
118106	7.046	
→ 119007	20.32	9.9 on 10/21

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	74878
Description: Support	Part Number:	D3278-1
Inspection Dwg: D3278 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.098	✓		Vern SL-3	
0.359	+/-0.005	.359	✓			
0.609	+/-0.010	.612	✓			
0.250	+/-0.010	.250	✓			
1.480	+/-0.005	1.480				
R0.125	+/-0.010	.125	✓			
0.119	+0.005/-0.004	.120	✓			
2.439	+/-0.010	2.438	✓			
1.980	+/-0.010	1.980	✓			
R0.13	+/-0.030	.13	✓			
Ø0.257	+0.005/-0.000	.258	✓			
R0.375	+/-0.010	.375	✓			
0.875	+/-0.010	.875	✓			
0.500	+/-0.010	.500	✓			
R0.400	+/-0.010	.400	✓			
R1.00	+/-0.030	1.00	✓			
1.720	+/-0.010	1.720	✓			
R0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.127	✓			

Measured by:	JK	Audited by:	RP	Prototype Approval:	N/A
Date:	11-10-26	Date:	11-10-26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	PE

W/O:		WORK ORDER CHANGES					
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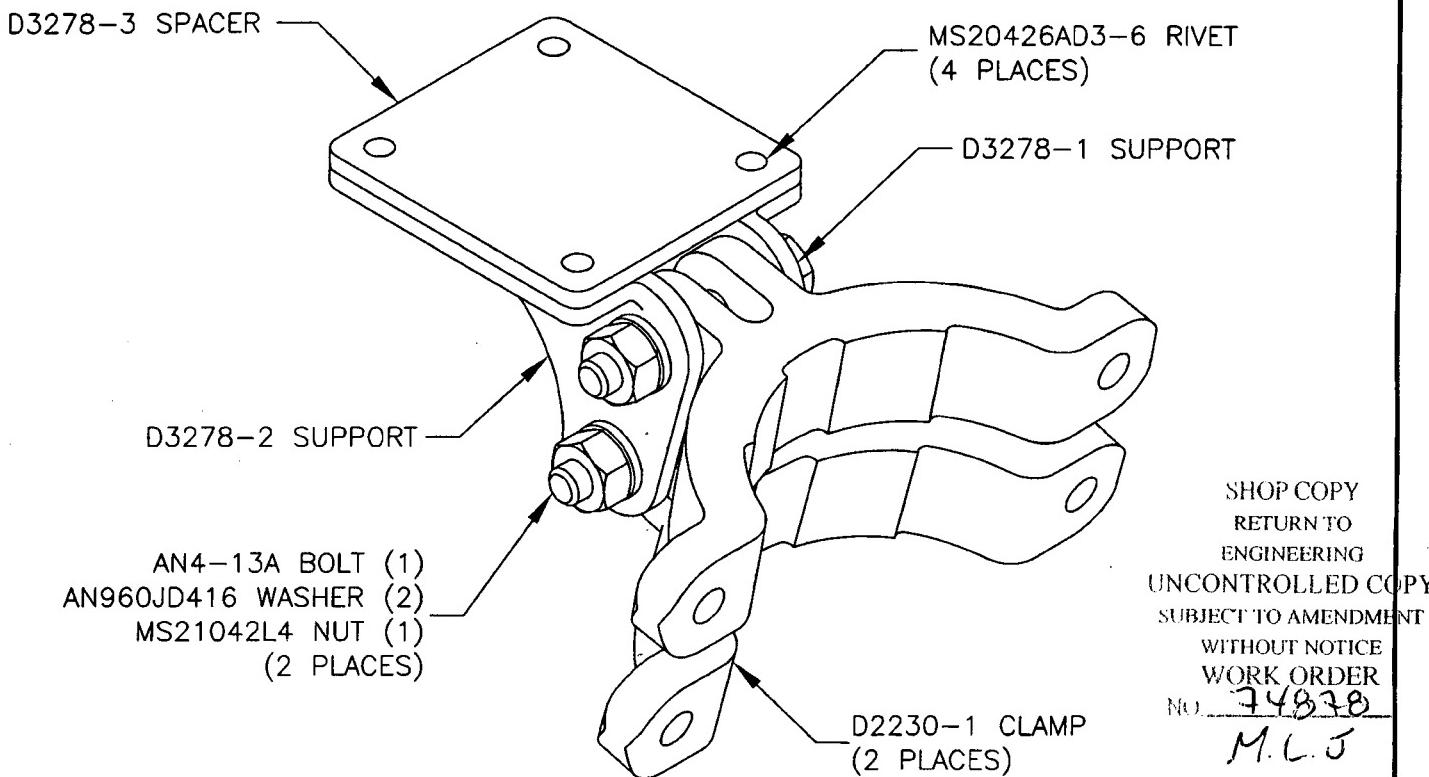
NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>B</i>	APPROVED <i>MM</i>	DRAWING NO.	D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE	SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE		
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT		
C	07.07.24	CHANGED RIVETS PER PAR #185		

RELEASED
07.08.08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

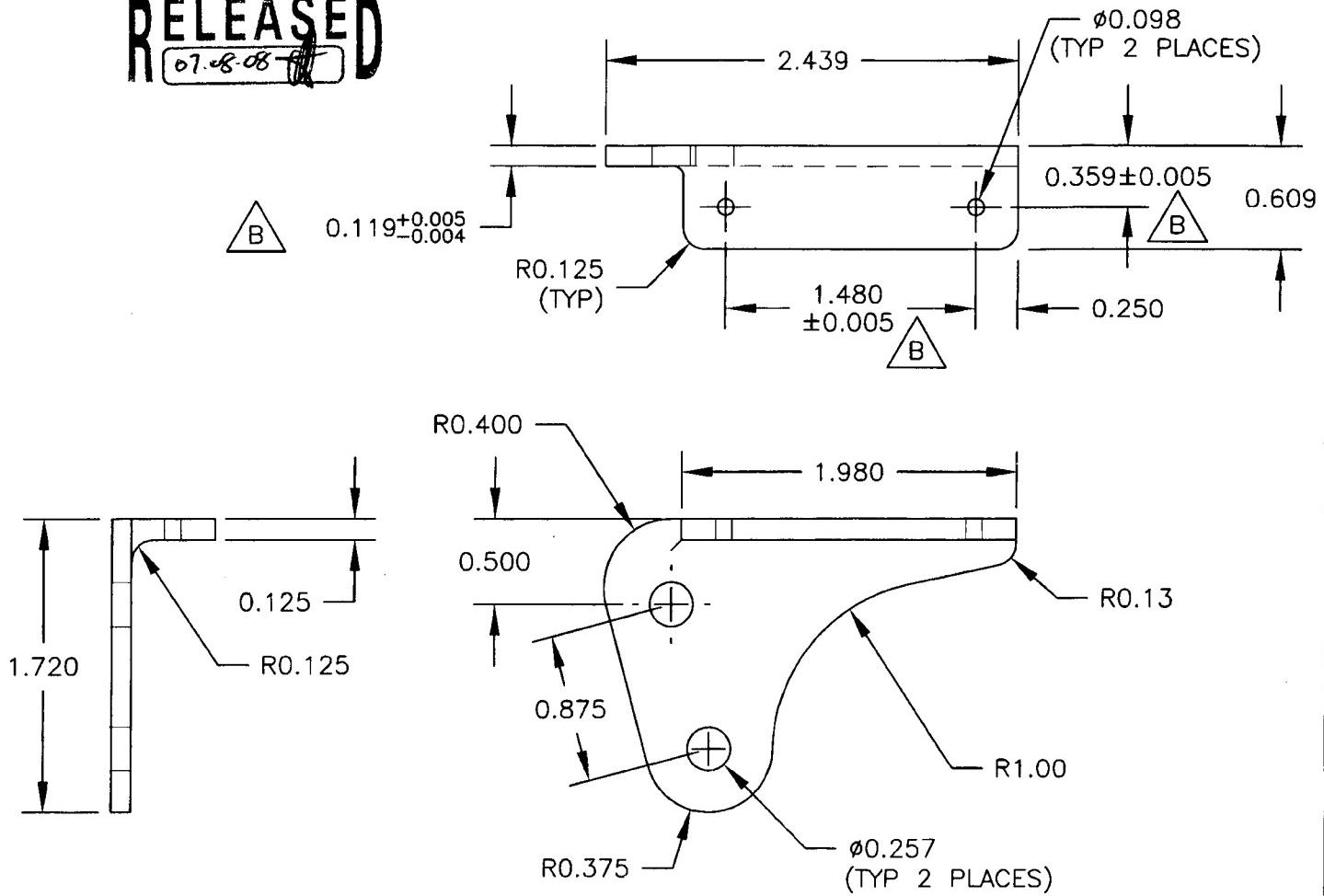
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278
DATE 07.07.24		REV. C SHEET 2 OF 3 TITLE SCALE 1:1 SUPPORT ASSEMBLY

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRPT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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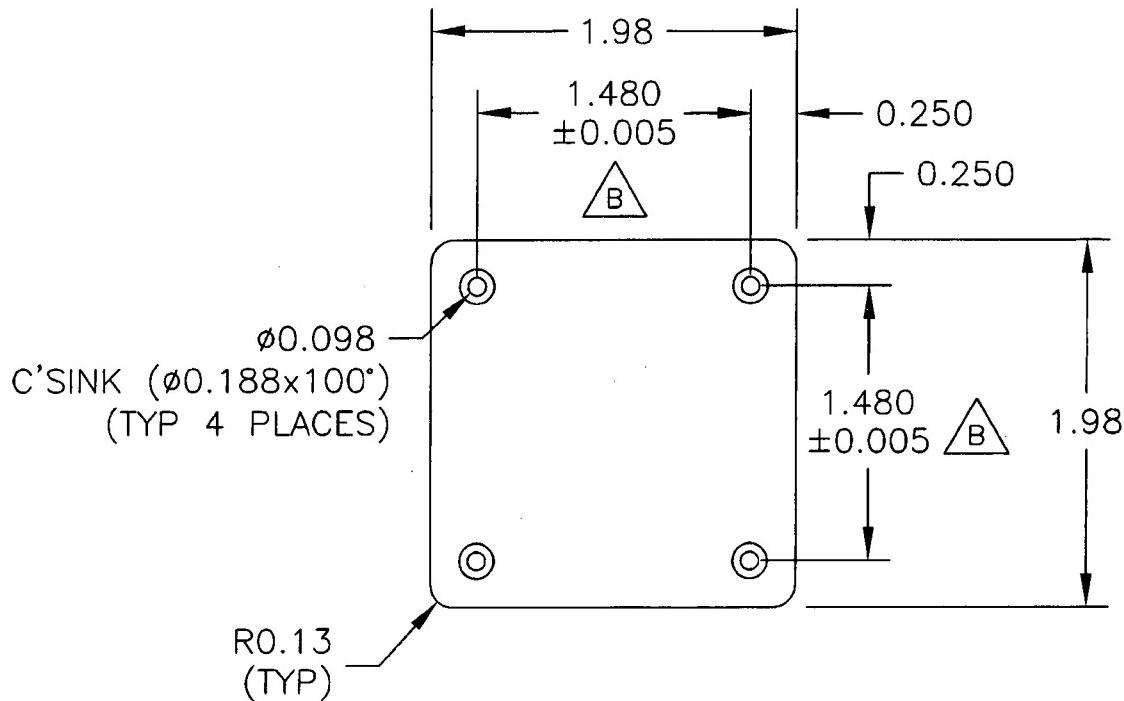
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DART

DESIGN <i>GP</i>	DRAWN BY <i>JG</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>JF</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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